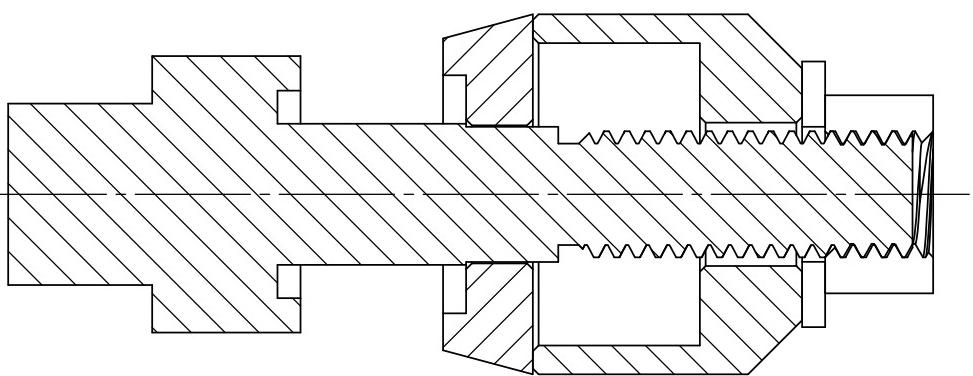


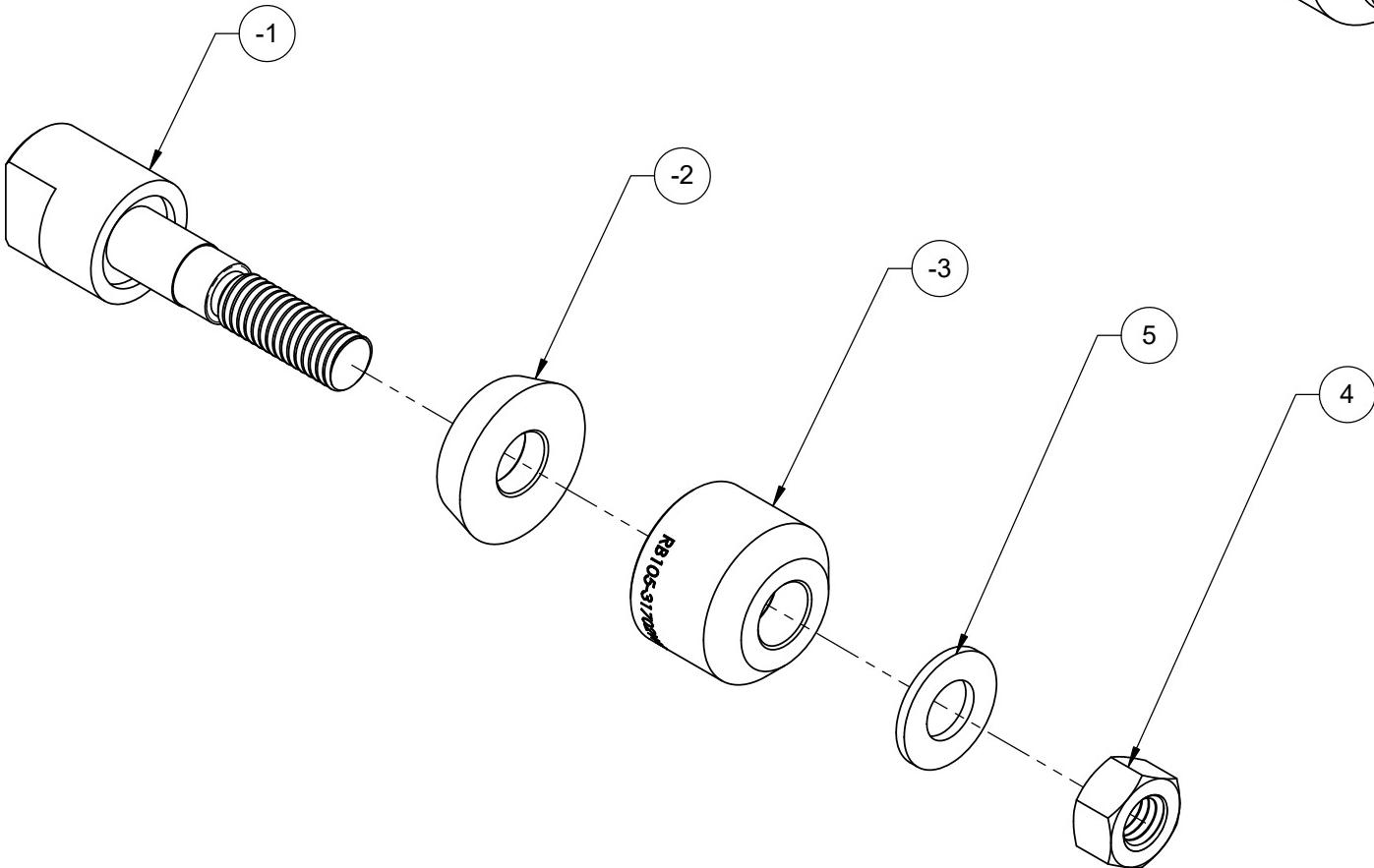
8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE105-31702W4-1	BOLT
-2	1	RBE105-31702W4-2	DRAWING IN DISC
-3	1	RBE105-31702W4-3	SUPPORT BODY
4	1	MS51967-12	NUT
5	1	NAS1149F0763P	WASHER



RBE105-31702W4 PRESSING IN & PUSHING OUT TOOL

9



NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

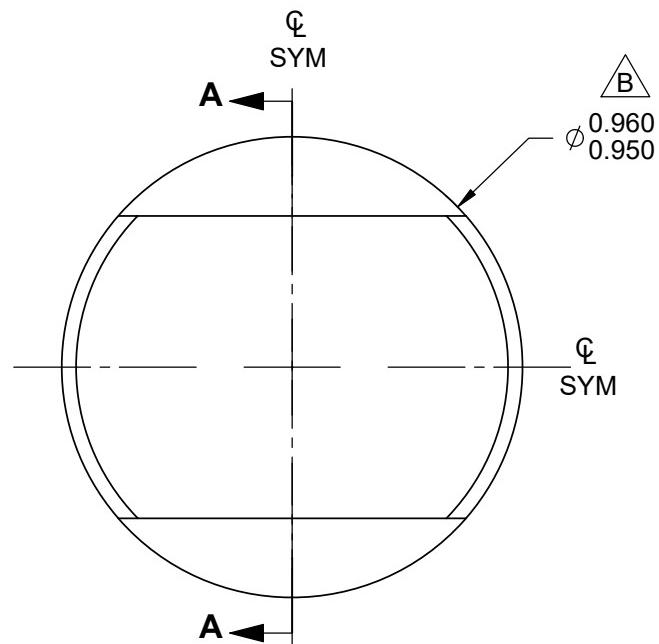
6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

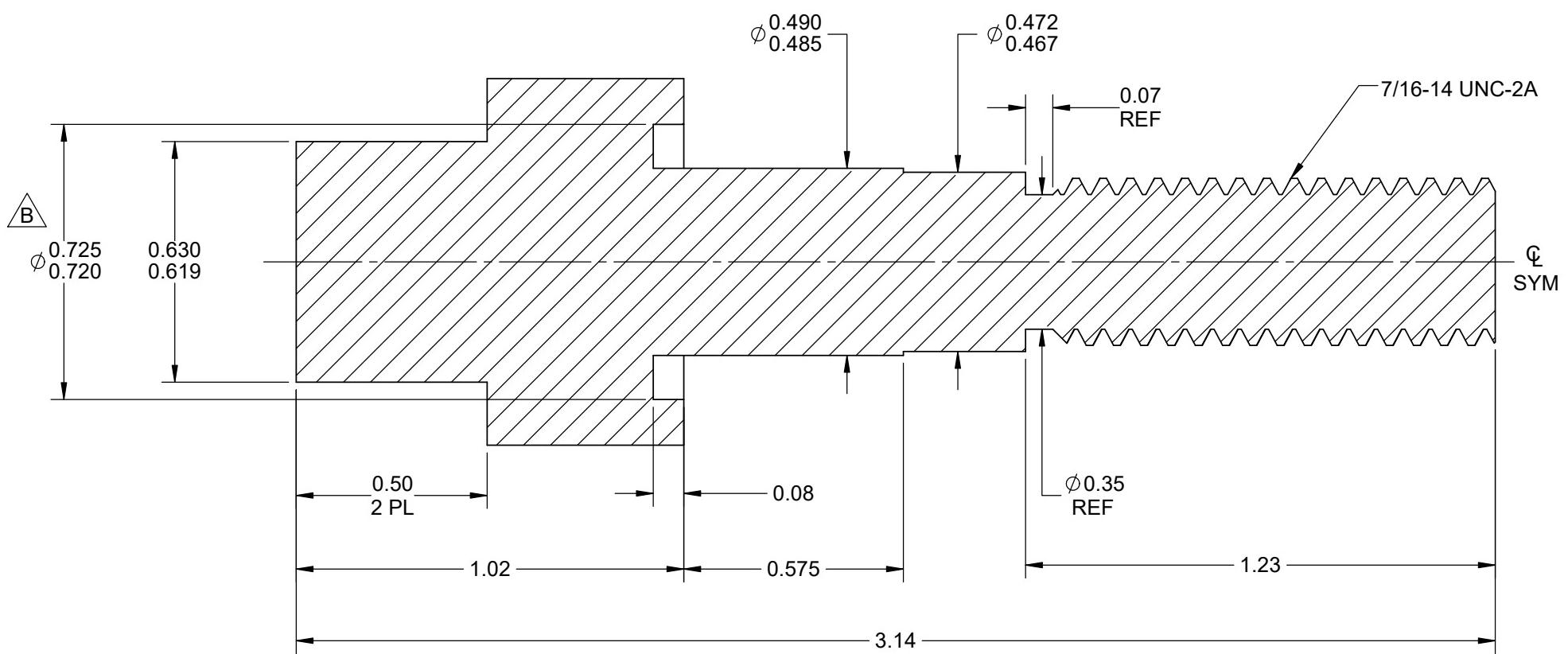
8) ASSEMBLE AS SHOWN

9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

B	-1: $\phi 0.960/0.950$ WAS $\phi 0.820/0.810$ & $\phi 0.725/0.720$ WAS $\phi 0.700$. UPDATED BOM WITH STANDARD P/N HARDWARE. REASON ECR 388			HB ECR 388	RF
A	NEW ISSUE			18-836	KK
REV.	DESCRIPTION			ECN #	BY
	DESIGN	KK		DART AEROSPACE LTD	
	DRAWN	RF		HAWKESBURY, ONTARIO, CANADA	
	CHECKED	KPT	TOOL P/N	RBE105-31702W4	REV. B
	MFG. APPR.	RQ			SHEET 1 OF 4
	APPROVED	SAD	TITLE	PRESSING IN & PUSHING OUT TOOL	NTS
			SCALE		(+/-)
	DATE	22.04.14	COPYRIGHT © 2018 BY DART AEROSPACE LTD		
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RBE105-31702W4-1 BOLT



SECTION A-A

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER
OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III
OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X XXXX = +/- 0.0005" / +/- 0.05°

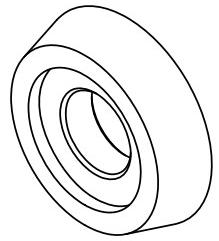
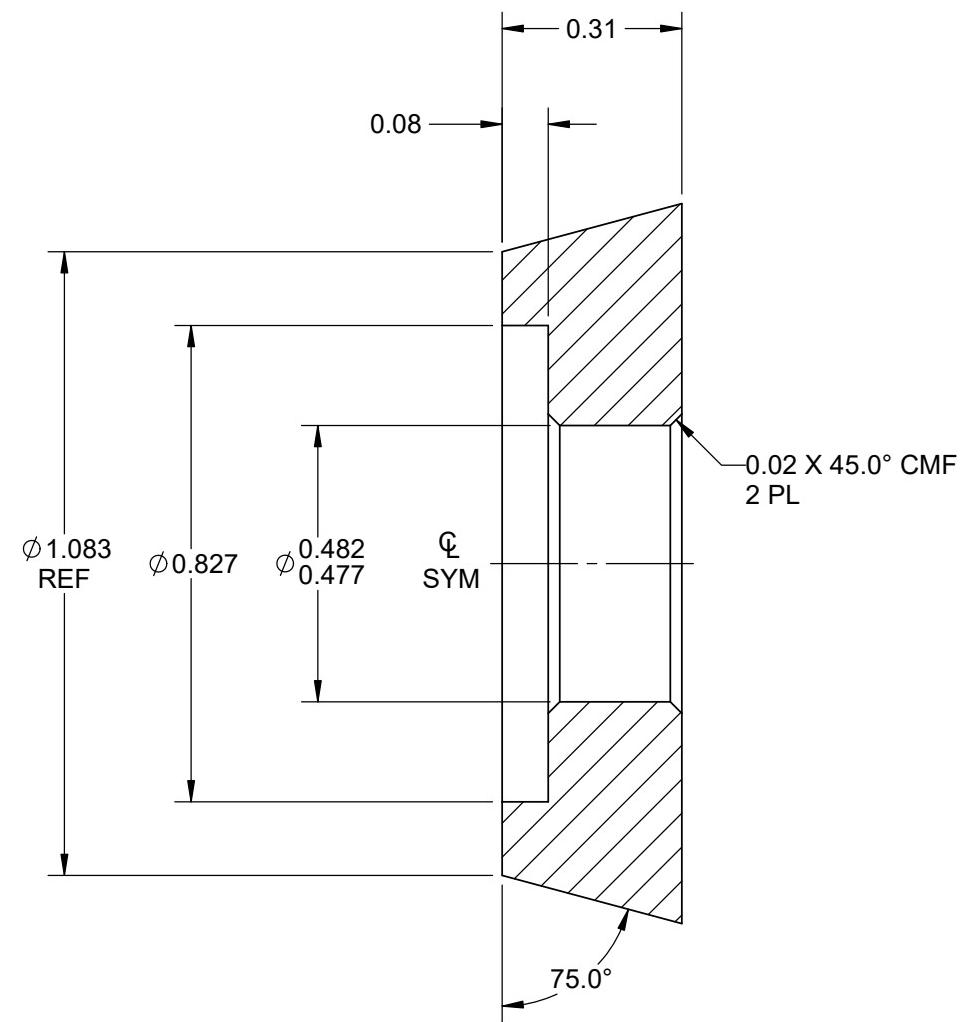
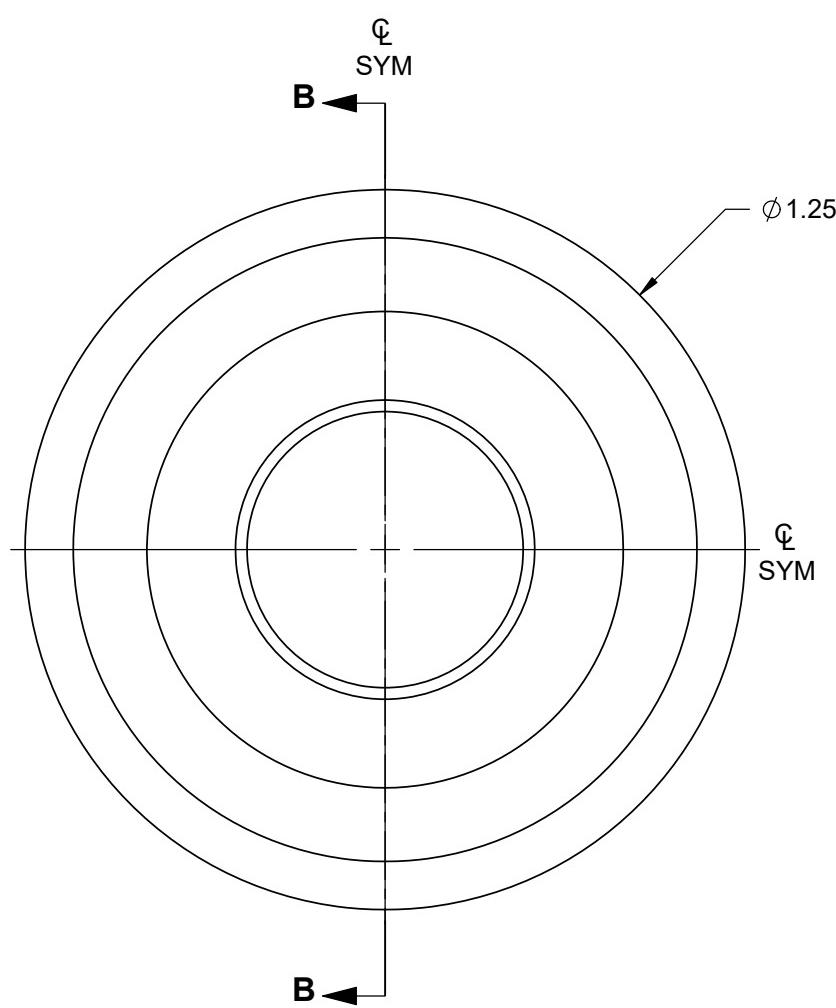
PARALLELISM, ECCENTRICITY

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES 0.005" TO 0.010"

6) BREAK SHARP EDGES: (

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KPT	TOOL P/N	REV. B
MFG. APPR.	RQ	RBE105-31702W4	
APPROVED	SAD	TITLE PRESSING IN & PUSHING OUT TOOL	SCALE NTS
DATE	22.04.14	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



RBE105-31702W4-2 DRAWING IN DISC

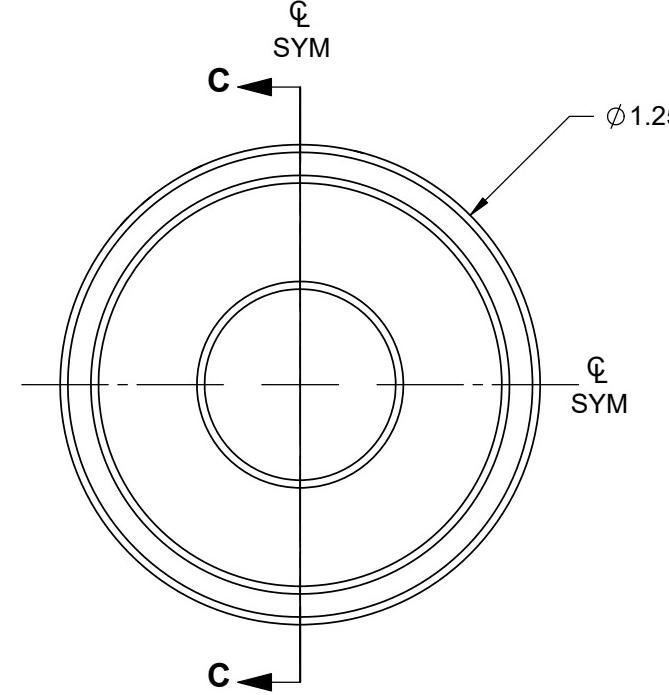
SECTION B-B

NOTES:

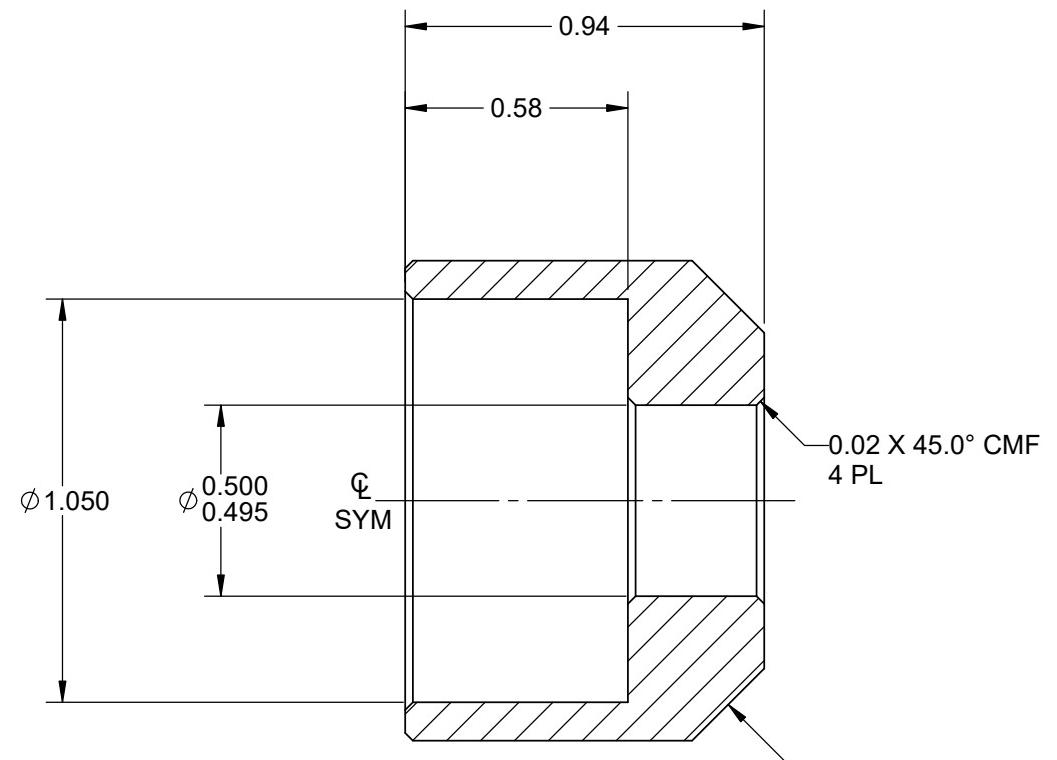
- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	KK	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. B	
MFG. APPR.	RQ	TOOL P/N RBE105-31702W4	
APPROVED	SAD	SHEET 3 OF 4	
TITLE PRESSING IN & PUSHING OUT TOOL		SCALE NTS	
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8 7 6 5 4 3 2 1



RBE105-31702W4-3 SUPPORT BODY



SECTION C-C

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N (RBE105-31702W4) AS SHOWN.

DESIGN	KK	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. B	
MFG. APPR.	RQ	RBE105-31702W4	
APPROVED	SAD	SHEET 4 OF 4	
TITLE		PRESSING IN & PUSHING OUT TOOL	
DATE 22.04.14		NTS	SCALE
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